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(54) Title: **HYDROLYTICALLY STABLE PHTHALATE ESTER LUBRICANTS AND METHOD OF METAL WORKING WITH HYDROLYTICALLY STABLE PHTHALATE ESTERS LUBRICANTS**

(57) Abstract: A water-based lubricant is provided that includes a phthalate ester in an amount of about 2 % to about 20 % based on the weight of the final composition and water in an amount of about 60 % to about 93 % based on the weight of the final composition. Also provided are a method of making the water-based lubricant and a method of metalworking using the water-based lubricant.

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